

## Claims

1. A laminate composite sheet comprising:  
a two-ply base layer comprised of a bottom ply and a top ply, wherein the bottom ply is comprised of unbleached cellulosic fibers and wherein the top ply is comprised of bleached or brightened cellulosic fibers;  
a further layer attached to the top ply with a layer of adhesive; said further layer having a top and a bottom surface, said further layer selected from the group consisting of paper or film; said layer of adhesive containing no pigment, and said top surface of said further layer having no coating.
2. The composite sheet of claim 1 wherein said sheet is capable of making products having high quality graphics.
3. The composite sheet of claim 1 wherein said unbleached cellulosic fibers are selected from the group consisting of unbleached virgin kraft pulp and unbleached recycled pulp.
4. The composite sheet of claim 1 wherein said bottom ply is substantially thicker than said top ply.
5. The composite sheet of claim 1 wherein the top ply has a brightness of above 60 ISO.
6. ~~The composite sheet of claim 1 wherein the top ply has enhanced smoothness.~~
7. The composite sheet of claim 3 wherein the adhesive is a barrier for moisture, oil and odor.
8. The composite sheet of claim 1 wherein the paper sheet is a publication grade paper.

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9. ~~The composite sheet of claim 1 wherein the paper sheet is a table stock-grade.~~

10. The composite sheet of claim 9 wherein the paper sheet has a coating.

11. The composite sheet of claim 10 wherein the coating is selected from the group consisting of clay and protein and/or starch or Titanium Dioxide

12. The composite sheet of claim 1 wherein said film is a tear resistant film.

13. The composite sheet of claim 1 wherein said film is reverse printed.

14. The composite sheet of claim 1 wherein said film contains a pigment.

15. The composite sheet of claim 1 further including an additional layer of paper or board attached to said bottom ply with a second adhesive layer.

16. The composite sheet of claim 15 wherein said additional layer is comprised of unbleached cellulosic fibers selected from the group consisting of unbleached virgin kraft pulp and unbleached recycled pulp.

17. The composite sheet of claim 15 wherein said additional layer is a moisture absorbent layer.

18. The composite sheet of claim 17 wherein the second adhesive layer is not significantly absorbed by the moisture absorbent layer, and the second adhesive layer acts as a moisture barrier.

19. The composite sheet of claim 15 wherein said second adhesive layer is selected from the group consisting of hot melt glues or glues that are moisture and/or oil resistant.

20. A laminated composite sheet comprising:

a pair of two-ply base layers, comprised of a bottom ply and a top ply,

wherein the bottom ply is comprised of unbleached cellulosic fibers and wherein the top ply is comprised of bleached or brightened cellulosic fibers; and

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an adhesive layer is disposed between the base layers, serving to adhere the bottom plies of each base layer together so that the top plies remain visible.

~~21.~~ The composite sheet of claim 20 wherein said sheet is used to make products having high quality graphics.

22. The composite sheet of claim 1 further comprising a second two-ply base layer comprised of a bottom ply and a top ply, wherein the bottom ply is comprised of unbleached cellulosic fibers and wherein the top ply is comprised of bleached or brightened cellulosic fibers;

said bottom ply of said second two-ply base layer attached to the bottom ply of said two-ply base layer with a second layer of adhesive.

23 The composite sheet of claim 22 further comprising a layer attached to the top ply of said second two ply base layer with a layer of adhesive; said layer having a top and a bottom surface, said layer selected from the group consisting of paper or film; said layer of adhesive containing no pigment, and said top surface of said layer having no coating.

~~24.~~ A method for forming a laminated composite sheet comprising:  
preparing a top ply comprised of bleached or brightened cellulosic fibers;  
preparing a bottom ply comprised of unbleached cellulosic fibers;  
pressing together in a press section of a papermachine said top ply and said bottom ply to form a two-ply base layer;  
attaching a further layer with an adhesive to said top ply; said further layer selected from the group consisting of paper or film; said adhesive containing no pigment.'

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25. The method of claim 24 further comprising:  
adding an additional layer of paper or board to said bottom ply with a second adhesive layer.
26. The method of claim 24 further comprising:  
adding a second two ply base layer: comprised of a bottom ply and a top ply;  
wherein the bottom ply is comprised of unbleached cellulosic fibers and wherein said top ply is comprised of bleached or brightened cellulosic fibers;  
attaching said bottom ply of said second two-ply base layer to said bottom ply of said two-ply base layer with a second layer of adhesive.
27. The method of claim 26 further comprising;  
attaching to said top ply of said second two-ply base layer with a layer of adhesive, a layer selected from the group consisting of paper or film; said adhesive containing no pigment.
- ~~28.~~ A method for forming a laminated composite sheet comprising:  
preparing a pair of two ply base layers comprised of a bottom ply and a top ply;  
preparing said top ply comprised of bleached or brightened cellulosic fibers  
preparing a bottom ply comprised of unbleached cellulosic fibers;  
pressing together in a press section of a papermachine said top ply and said bottom ply to form a two-ply base layer;  
attaching said base layers together with an adhesive;  
said base layers being attached by said bottom plies so that the top plies remain visible.

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